

Ship Oct. 25

Work Order ID 62586 - 2

Monday, October 04, 2010 3:21:46 PM



Page 1

Item ID: D206-628-022BL

Revision ID:

Item Name: Heli-Access-Step RH, Blue

Start Date: 10/5/2010 Start Qty: 4.00

Required Date: 10/29/2010 Req'd Qty: 4.00

Reference:

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Approvals: Process Plan: mf

QC:

Date: 10-10-04

Tooling:

Date:

Run Start



Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

100



DC

Document Control

DOCUMENT CONTROL

0.00

Memo

0.00

Photocopy blue file and type labels as per PPP D206-628-022 CHG 003

8/10/11/09

8/10/11/09 BG 10-10-19

110



Packaging

Packaging

Pick Kit

0.00

Memo

0.00

10/10/19 sf

120



QC

Quality Control

QC4- 100% Inspect kits for completeness

0.00

Memo

0.00

8/10/11/09

42 RH

Work Order ID 62586

Monday, October 04, 2010 3:21:46 PM



Page 2

Item ID: D206-628-022BL

Accept



Setup Start



Revision ID:

Item Name: Heli-Access-Step RH, Blue

Stop



Start Date: 10/5/2010 Start Qty: 4.00



Cust Item ID:

Required Date: 10/29/2010 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

0.00



Packaging

Packaging

Memo

0.00

Identify and pack for shipping as per PPP D206-628-022

Location: 114

PPP Rev: 5

140

0.00



QC

Quality Control

QC21- Final Inspection - Work Order Release

Memo

0.00

10/11/09

20

10/11/09

ms

10-11-9

Picklist Print

Monday, October 04, 2010 3:21:46 PM

Page 1

Work Order ID: 62586

Parent Item: D206-628-022BL

Parent Item Name: Heli-Access-Step RH, Blue



Start Date: 10/5/2010

Required Date: 10/29/2010

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP RevF: add D2724-042 DD 09.11.17 verified by:ec

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

AN4-14A

Purchased

No

Each

168.0000

4

10



Bolt

Location

Loc Qty

Loc Code

ST357

152

114752

1

115371

150

115422

1

ST358

16

113359

16

AN4-15A

Purchased

No

Each

577.0000

8

32



Bolt

Location

Loc Qty

Loc Code

ST338

112

ST358

465

107737

12

108868

60

109148

4

111295

52

112905

12

114232

3

114292

32

114615

56

114784

58

115108

76

115371

100

31

Picklist Print

Monday, October 04, 2010 3:21:46 PM

Page 2

Work Order ID: 62586

Parent Item: D206-628-022BL

Parent Item Name: Heli-Access-Step RH, Blue

Start Date: 10/5/2010

Required Date: 10/29/2010

Start Qty: 4.00

Required Qty: 4.00

AN960JD416 NAS1149D0463J Purchased No

Each

24.0000

12

48



Washer

Location

Loc Qty

Loc Code

ST300

24

113288

24

Each

0.0000

1

D2724-042

Manufactured No



206L Step Assembly

D2731-7

Manufactured No

Each

55.0000

4



Mounting Lug

Location

Loc Qty

Loc Code

ST420

16

60996

16

ST470

39

59202

15

61653

24

Each

0.0000

8

D2732-030

Manufactured No



Rubber Cushion

D3394-043

Manufactured No

Each

31.0000

4

16



Lug Assembly

Location

Loc Qty

Loc Code

ST420

19

60997

19

ST475

12

52331

12

rotated mislabeled

362588 rotated

362590 10/10/10

32 x feet rotated

362589 10/10/10

Monday, October 04, 2010 3:21:46 PM

Shop Packet Print

Page 2

Picklist Print

Monday, October 04, 2010 3:21:46 PM

Page 3

Work Order ID: 62586

Parent Item: D206-628-022BL

Parent Item Name: Heli-Access-Step RH, Blue



Start Date: 10/5/2010

Required Date: 10/29/2010

Start Qty: 4.00

Required Qty: 4.00

MS21042L4

Purchased

No

Each

4,434.000

12

48



Nut

10/10/19 54 (40)

Location

Loc Qty

Loc Code

ST300

4434

113422

68

114523

8

114718

16

114784

32

115108

1310

115589

1900

115621

1100

48

Monday, October 04, 2010 3:21:46 PM

Shop Packet Print

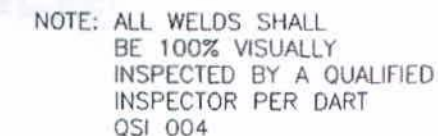
Page 3

5.1 D206-628-011/-012/-021/-022/-031/-032 REGULAR DART HELI-ACCESS-
STEPS™ PARTS LIST

Qty -011	Qty -012	Qty -021	Qty -022	Qty -031	Qty -032	Part Number	Description
X						D206-628-011	206 A/B STEP INSTALLATION LH
	X					D206-628-012	206 A/B STEP INSTALLATION RH
		X				D206-628-021	206 L/L1/L3/L4 STEP INSTALLATION LH
			X			D206-628-022	206 L/L1/L3/L4 STEP INSTALLATION RH
				X		D206-628-031	407 STEP INSTALLATION LH
					X	D206-628-032	407 STEP INSTALLATION RH
1						D2721-041	STEP ASSEMBLY LH
	1					D2721-042	STEP ASSEMBLY RH
		1		1		D2724-041	STEP ASSEMBLY LH
			1		1	D2724-042	STEP ASSEMBLY RH
2	2			4	4	D2731-3	MOUNTING LUG
2	2	4	4			D2731-7	MOUNTING LUG
8	8	8	8	8	8	D2732-030	RUBBER CUSHION
2	2			4	4	D3394-041	MOUNTING LUG
2	2			4	4	*D3394-1	*MOUNTING LUG
4	4			8	8	*MS35489-93	*GROMMET
2	2	4	4			D3394-043	MOUNTING LUG
2	2	4	4			*D3394-3	*MOUNTING LUG
4	4	8	8			*MS35489-93	*GROMMET
4	4			4	4	AN4-13A	BOLT
4	4	4	4	4	4	AN4-14A	BOLT
4	4	8	8	4	4	AN4-15A	BOLT
12	12	12	12	12	12	AN960JD416	WASHER
12	12	12	12	12	12	MS21042L4	NUT (OR MS21042-4)

*DENOTES THAT PART IS INCLUDED IN ASSEMBLY ABOVE

DESIGN KE	DRAWN BY PH	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED PH	APPROVED PH	DRAWING NO. D2724	REV. C SHEET 1 OF 1
DATE 05.09.19	TIME 206L/407 STEP ASSEMBLY SCALE NTS		
A	97.12.04	NEW ISSUE	
B	98.10.19	UPDATED WELD DETAIL REVISED TOLERANCES	
C	05.09.19	RE-DESIGN ADD D3458-1/3	



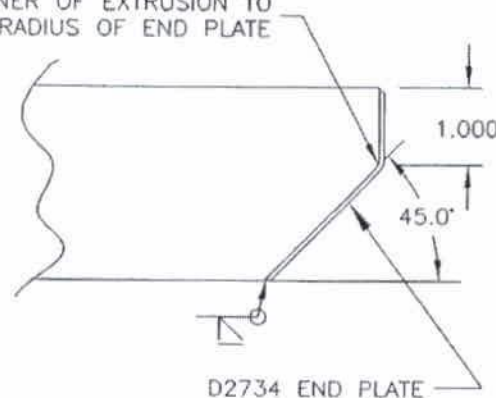
APPLY BLACK
ANTI-SKID ON
- TOP SURFACE
TO BOTTOM
OF TOP RADIUS

— REFER TO STEP
END DETAIL

D2724-1
MAKE FROM EXTRUSION D2622-107

D2724-041 LH STEP ASSEMBLY (SHOWN)
D2724-042 RH STEP ASSEMBLY (OPPOSITE)

ROUND CORNER OF EXTRUSION TO
MATCH BEND RADIUS OF END PLATE



D2734 END PLATE

TYPICAL STEP END DETAIL
NOT TO SCALE

D2721-041/-042 STEP ASSEMBLY PARTS LIST

QTY - 041	QTY - 042	PART NUMBER	DESCRIPTION
X		D2724-041	LH STEP ASSEMBLY
	X	D2724-042	RH STEP ASSEMBLY
1	1	D2622-107	EXTRUSION
2	2	D2734	END PLATE
2	2	D3458-1	PLATE
2	2	D3458-3	PLATE

D2724-041/-042 STEP ASSEMBLY

- 1) MAKE FROM EXTRUSION D2622 TYPICAL S
2) WELD PER DART QSI 004 NOT
3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
APPLY BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
4) ALL DIMENSIONS ARE IN INCHES
5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

Copyright © 2005 by DART AEROSPACE USA, INC.

